



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBW109-3130-88-101
Job Sheet 196440



Part No: RBW109-3130-88-101

Job Qty: 1 pcs

Part Name: Tail Rotor Hub Trunnion Centering



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/13/19

Job Tracking No: re-plate

Due Date: 6/21/19

Created By: Linda Lacelle

Type: AOG

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
94	Rework - 1 - Startup	1 pcs	6/21/19		0.00	0.50	Small Fab - 1		MCC
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
95	QC 5	1 pcs	6/21/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
96	Outsource - 3 - Cadplate	1 pcs	6/21/19		0.00	0.00	GRO 002		2019-06-17
97	Packaging 2-1 - Receive - B4B	1 pcs	6/21/19		0.00	0.00	Packaging 2 - 1 - B4B		
							Packaging 2 - 2 - B4B		
							Packaging 2 - 3 - B4B		
							Packaging 2 - 5 - B4B		
							Packaging 2 - 4 - B4B		
							Packaging 2 - 6 - B4B		
							Packaging 2 - 7 - B4B		



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1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S190037



Part: RBW109-3130-88-101

Job No: 196440

Serial No/Batch: S190037

Revision:

Inspector:

Exp Date:

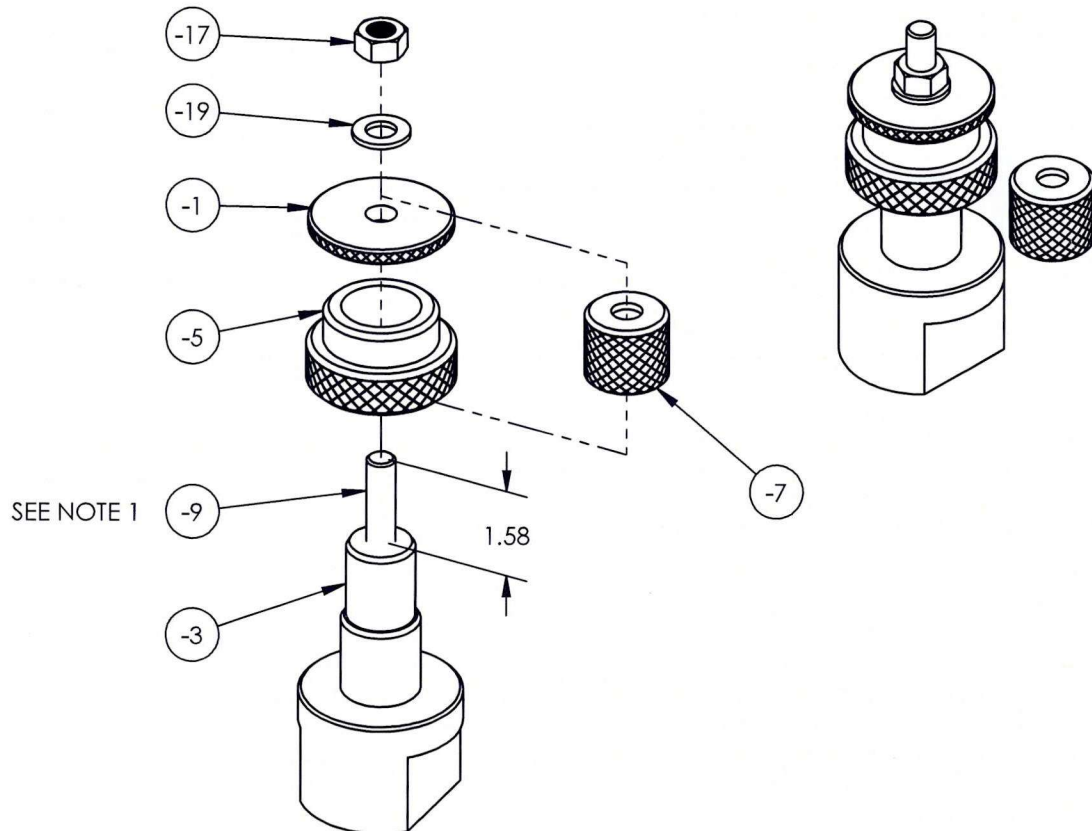
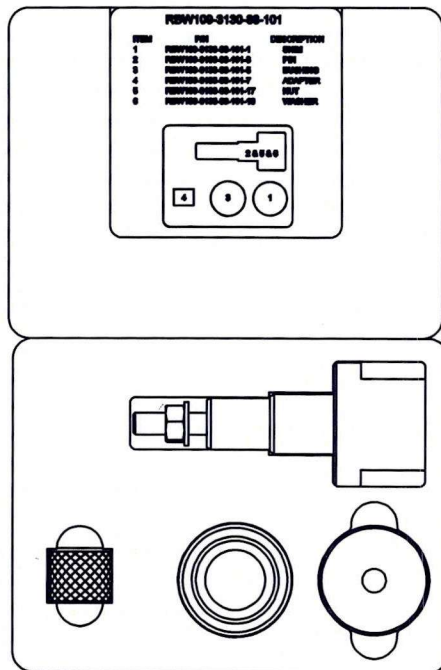
Instructions:

Date: 06/13/19

					Packaging 2 - 8 - B4B	
					Packaging 2 - 9 - B4B	
					Packaging 2 - 10 - B4B	
					Packaging 2 - 11 - B4B	
					Packaging 2 - 12 - B4B	
					Packaging 2 - 13 - B4B	DP JUN 21 2019
					Packaging 2 - 14 - B4B	
					Packaging 2 - 15 - B4B	
					Packaging 2 - 16 - B4B	
					Packaging 2 - 17 - B4B	
					Packaging 2 - 18 - B4B	
					Packaging 2 - 19 - B4B	
					Packaging 2 - 20 - B4B	
					Packaging 2 - 21 - B4B	
					Packaging 2 - 22 - B4B	
					Packaging 2 - 23 - B4B	
					Packaging 2 - 24 - B4B	
					Packaging 2 - 25 - B4B	
					Packaging 2 - 26 - B4B	
					Packaging 2 - 27 - B4B	
					Packaging 2 - 28 - B4B	
					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
98	QC 6	1 pcs	6/21/19	0.00 0.00	QC 6 - 9	
					QC 6 - 68	
					QC 6 - 61	
					QC 6 - 40	DAS 40 JUN 24 2019 9-89
120	Packaging 3-1 - Stock - B4B	1 pcs	6/21/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	GA-TBD
130	QC 21 - FG	1 pcs	6/21/19	0.00 0.00	QC 21 - FG - 21	
					QC 21 - FG - 70	
					QC 21 - SA - 53	DAS 53 JUN 24 2019 9-89
Part Op 94 - DEASSEMBLE KIT TO HAVE PARTS RE CAD PLATE INDIVIDUALLY Descriptions: 96 - ISSUE P/O: <u>POH508750</u> CAD PLATE YELLOW QQ-P-416F, TYPE II, CLASS II (MATERIAL 4140 Q&T) C OF C IS REQUIRED						
Job BOM						
Part / Item	Component Name	Quantity	Operation	Container		
RBW109-3130-88-101p	T/R HUB TRUNNION CENTERING	1 pcs (1 ea)	94-Rework - 1 - Startup	RB4012-02		
Job Allocations						
Operation	Component Part	Required	Inventory	Allocated		
94-Rework - 1 - Startup	RBW109-3130-88-101p	1	4	0		
Part Specifications						
Specifications could not be found.						

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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
A	SHT 8 CORRECTED LAYOUT #'S, 3 WAS 5, 2 & 5 & 6 WAS 1 & 5 & 6.	11/30/2012	JAG	
1A	-11 DIM WAS 9.19 IS 9.41. -13 DIM WAS 7.12 IS 7.19, CHANGED PLACARD CUTOUT DEPTH WAS .06 IS .125.	1/3/2013	BIM	SE



NOTE:
USE PERMANENT THREAD LOCKER ON -9 STUD.

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	SHIM	4140 Q & T	Ø2-1/2 X 3/8	2
			-3	1	PIN	4140 Q & T	Ø2-3/4 X 4-7/8	3
			-5	1	BUSHING	4140 Q & T	Ø2-5/8 X 1-1/2	4
			-7	1	ADAPTER	4140 Q & T	Ø1-3/8 X 1-5/16	5
		B/O	-9	1	STUD	STEEL	M12 X 1.75 X 60mm MCMASTER-CARR #93675A370	1
			-11	1	BOTTOM TOOL CUSHION	Y-20, BLACK	9.19 X 7.23 X 2.93	6
			-13	1	TOP TOOL CUSHION	C200 BLACK, FLAT	7.12 X 9.37 X 1.19	7
			-15	1	PLACARD	ALUMINUM	1/16 X 5 X 5	8
		B/O	-17	1	NUT	STEEL	M12 X 1.75 MCMASTER-CARR #92497A500	1
		B/O	-19	1	WASHER	STEEL	M12 MCMASTER-CARR #91166A290	1
		B/O	-21	1	CASE	PLASTIC	PELICAN APP-1200-E	NS



RED BARN MACHINE

T/R HUB TRUNNION CENTERING

RBW109-3130-88-101

REV 1A

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		DRAWN BY: GILBERT	
.XXX ± .005		APPROVED <i>D Weil</i>	
.XX ± .01		HEAT TREAT	
.X ± .1		FINISH	
1. BREAK ALL SHARP EDGES .015 x 45°		SPEC	
OR .015R		USED ON MODEL	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING		AW119	
SCALE	1:3	DATE	1/31/2012
		SHEET 1 OF 8	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **POHB043750**



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB043750

PO Date: 6/17/19

Due Date: 6/19/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments: ***RUSH PLEASE***

E-MAILED
2019-06-18

Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	196440	RBW109-3130-88-101	Tail Rotor Hub Trunnion Centering ISSUE P/O: _____ CAD PLATE YELLOW QQ-P-416F, TYPE II, CLASS II (MATERIAL 4140 Q&T) C OF C IS REQUIRED	Firmed - XI		6/19/19	1 pcs	0 pcs	1 pcs	\$350.00/pcs	\$350.00
Line Item Note NOTE - 1 kit = 5 pieces											Grand Total: \$350.00

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Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retension of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 6/21/19 3:37 PM Dart.Guerin.Kimberley



Certificat de Conformité / Certificate of Compliance

(020079-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

020079- 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
20-Jun-2019		SVETLANA DORZHIYEVA		POHB043750				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RBW109-3130-88-101 Rev.	RBW109-3130-88-101 01 -CAD YELLOW 500 [CADMIUM YELLOW 500] QQ-P-416F, TYPE 2, CLASS 2 STRIP YELLOW CAD BEFORE PLATING THEN CAD PLATE	CADMIUM LOT	5	5	0	0	0

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RECEIVED

JUN 21 2019

DART AEROSPACE LTD.

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Je

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.